

Work Order ID 58155

April 26, 2010 2:18:32 PM



Page 1

Item ID: D4054-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 4/26/10 Start Qty: 8.00



Cust Item ID:

Required Date: 5/04/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *u*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4054

A

8X

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Bend tube as per Dwg D4054

Install sleeves and nuts

Flare ends as per Dwg D4054.

=> M-1 10/08/16

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S. 10/08/16

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58155

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Page 2

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location: 51193

0.00



Packaging

Memo

0.00

Packaging

(X8) BB 10/08/18

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19
MF 10-8-19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 2:18:31 PM

Page 1

Work Order ID: 58155

Parent Item: D4054-001

Parent Item Name: Tube Assembly

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Date: 4/26/10

Required Date: 5/04/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN818-8D		Purchased	No			100	Each	29.0000	16.0000			
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Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST331

113795

114382

29

9

20

100

f

21.6072

14.9895

M6061T6T0.500W.049

Purchased

No



6061-T6 RD Tube .500 x.049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT014

111028

111944

21.6072

16.5895

5.0177

100

Each

40.0000

16.0000

MS20819-8D

Purchased

No



Sleeve

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST323

113795

40

40

M 115001

16x m-l
10/08/12

14.9895
m-l
10/08/11

16x m-l
10/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

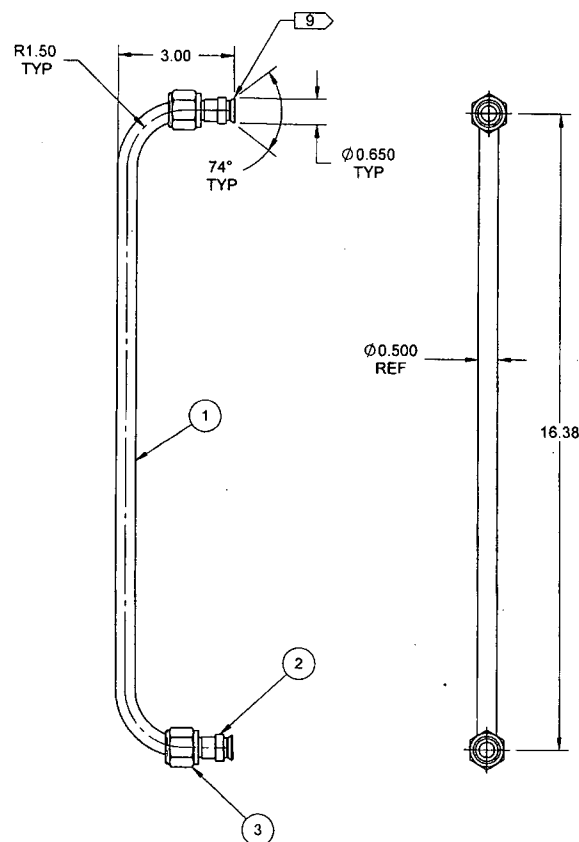
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY -001	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



D4054-001 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 8061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
MND

A		NEW ISSUE		RF	09.12.30
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	RF	DRAWING NO.	REV. A		
MFG. APPR.	RF	D4054	SHEET 1 OF 3		
APPROVED	RF	TITLE	SCALE		
DE APPR.	RF	TUBE ASSEMBLIES	NTS		
DATE	09.12.30		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

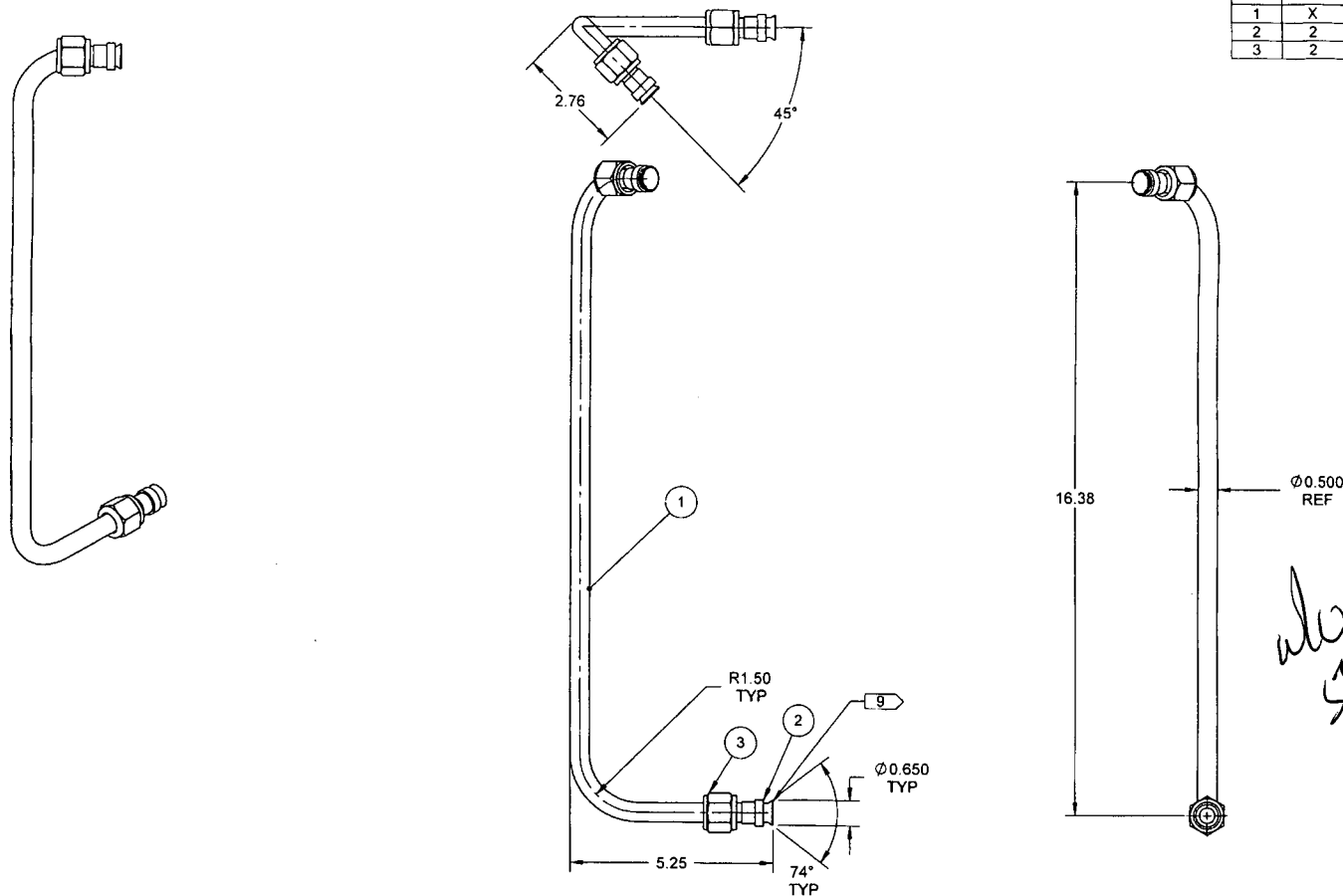
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -003	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-003T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

D4054-003 TUBE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D4054	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

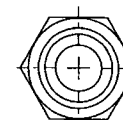
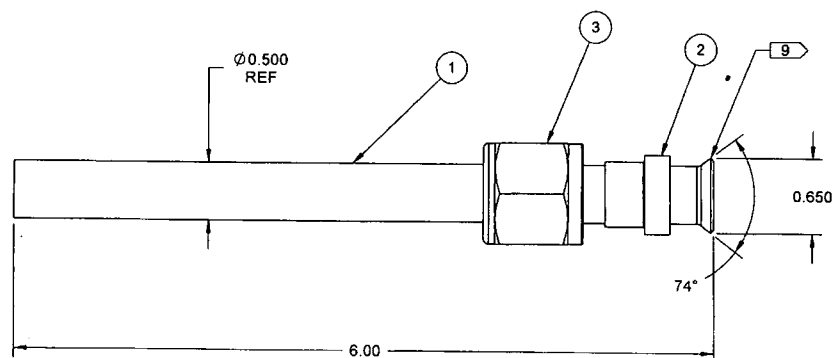
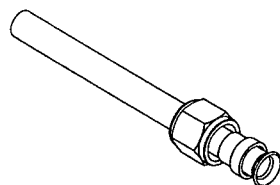
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -009	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



WLO 58155

D4054-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
WLO

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4054	REV. A
MFG. APPR.	RF	SHEET 3 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
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